

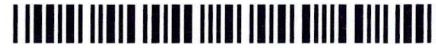


Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D2666-2

Job Sheet 193856



Part No: D2666-2

Job Qty: 6 pcs

Part Name: Saddle, RH, Fwd, Aft, In



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 4/23/19

Job Tracking No:

Due Date: 5/10/19

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG REV D IPP: C 00.11.01 Removed P/O for Powder Coat - in house process EC IPP Rev:D As per Rev D 07-03-19 JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	HAAS 4 Axis	6 pcs	5/10/19		0.00	6.00	HAAS - 1		
							HAAS - 2		
							HAAS - 3		SBL 19/05/21
							HAAS - 4		
110	Conventional Mill - 1 - B4B	6 pcs	5/10/19		0.00	0.93	Conventional Mill - 1 - B4B		SBL 19/05/21
							Conventional Mill - 2 - B4B		
120	QC 2	6 pcs	5/10/19		0.00	0.00	QC 2 - 1		
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		VHS 19/05/23
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		



Dart Aerospace Ltd.
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CANADA
TEL : 1 613 632-5200
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www.dartaerospace.com

Container No: S182378



Part: D2666-2

Job No: 193856

Serial No/Batch: S182378

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Date: 05/21/19

130 QC 8	6 pcs	5/10/19	0.00 0.00	QC 2 - 57	
				QC 2 - 62	
				QC 2 - 63	
				QC 2 - 8	
				QC 2 - 66	
				QC 2 - 64	
				QC 2 - 65	
				QC 2 - 5	
				QC 2 - 71	
				QC 8 - 12	
				QC 8 - 14	2019/05/23
				QC 8 - 17	
				QC 8 - 20	
				QC 8 - 25	
				QC 8 - 3	
				QC 8 - 32	
				QC 8 - 33	
QC 8 - 35					
QC 8 - 39					
QC 8 - 4					
QC 8 - 44					
QC 8 - 45					
QC 8 - 49					
QC 8 - 58					
QC 8 - 8					
QC 8 - 9					
QC 8 - 68					
QC 8 - 67					
QC 8 - 1 (A)					
QC 8 - 47					
QC 8 - 40					
QC 8 - 52					
QC 8 - 23					
140 Handfinish - 1-1 Chemical-B4B	6 pcs	5/10/19	0.00 0.71	Handfinish - 1 - 1 - B4B	
				Handfinish - 1 - 2 - B4B	
				Handfinish - 1 - 3 - B4B	2019 MAY 24 2019
				Handfinish - 1 - 4 - B4B	
				Handfinish - 1 - 5 - B4B	
				Handfinish - 1 - 6 - B4B	
				Handfinish - 1 - 7 - B4B	
				Handfinish - 1 - 8 - B4B	
				Handfinish - 1 - 9 - B4B	
				Handfinish - 1 - 10 - B4B	
				Handfinish - 1 - 11 - B4B	
				Handfinish - 1 - 12 - B4B	
				Handfinish - 1 - 13 - B4B	
				Handfinish - 1 - 14 - B4B	
				Handfinish - 1 - 15 - B4B	
				Handfinish - 1 - 16 - B4B	
				Handfinish - 1 - 17 - B4B	
				Handfinish - 1 - 18 - B4B	
				Handfinish - 1 - 19 - B4B	
				Handfinish - 1 - 20 - B4B	
				Handfinish - 1 - 21 - B4B	
				Handfinish - 1 - 22 - B4B	
150 Powdercoat - 1 White Gl(A)-B4B	6 pcs	5/10/19	0.00 0.20	Powdercoat - 1 - B4B	
				Powdercoat - 2 - B4B	
				Powdercoat - 3 - B4B	2019-5-21
				Powdercoat - 4 - B4B	
START: 8:35 ON T1320 FINISH: 9:05					
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160 QC 3	6 pcs	5/10/19	0.00 0.00	QC 3 - 10	
				QC 3 - 13	
				QC 3 - 15	
				QC 3 - 17	
				QC 3 - 18	
				QC 3 - 2	
				QC 3 - 28	
				QC 3 - 3	
				QC 3 - 30	
				QC 3 - 34	
				QC 3 - 36	
				QC 3 - 41	
				QC 3 - 51	
				QC 3 - 58	
				QC 3 - 59	
				QC 3 - 68	
				QC 3 - 9	
				QC 3 - 40	MAY 27 2019 DAS 40
				QC 3 - 19	9-89
170 Packaging 3-1 - Stock - B4B	6 pcs	5/10/19	0.00 0.00	Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	DAS 28
				Packaging 3 - 6 - B4B	9-89
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	DAS 21
180 QC 21 - SA	6 pcs	5/10/19	0.00 0.00	QC 21 - SA - 21	9-89
				QC 21 - SA - 70	21
				QC 21 - SA - 53	9-89 MAY 27 2019

Part Op 100 - HAAS CNC Vertical Machine - Program batch number. 1-Inspect part number and batch number are programmed

5182378

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Descriptions: correctly. 4-Machine Step No 1 of Folio and visually inspect as per attached Dimension Sheet 5-Machine Step No 2 of Folio and visually inspect as per attached Dimension Sheet 6
110 - Manufacture as per dwg - Machine Keyway and inspect per attached dimension sheet
120 - QC2- Inspect parts off machine FAI/FAIB
130 - QC8- Inspect parts - second check
140 - Chemical Conversion Coat per QSI005 4.1
150 - White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum) - START TIME: _____
160 - QC3- Inspect Part Finish
170 - Identify as per dwg & Stock Location: _____
180 - QC21- Final Inspection - Work Order Release

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D6101-001	Saddle Billet	6 pcs (1 ea)	100-HAAS 4 Axis	3x S133675 3x S166453

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-HAAS 4 Axis	D6101-001	6	23	0

Part Specifications

Specifications could not be found.

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DART AEROSPACE LTD				Work Order: 193856	
Description: 206 Saddle, Inboard, Right side				Part Number: D2666-2	
Inspection Dwg: D2666 Rev: D DSK: Rev:				Page 1 of 1	

FIRST ARTICLE INSPECTION DIMENSION SHEET

Dim	Min	Max	Go/No Go Gauge	Record Actual Dimensions				
				1	2	3	4	5
A	0.100	0.140		.122	.122	.122	.121	.121
B	0.100	0.140		.126	.117	.117	.117	.117
C	2.470	2.510		2.495	2.495	2.495	2.495	2.495
D	0.100	0.180		.130	.130	.130	.130	.128
E	0.210	0.230		.223	.223	.223	.223	.224
F	1.313	1.343		1.325	1.325	1.325	1.324	1.324
G	0.240	0.260		.254	.254	.254	.254	.254
H	0.615	0.685		.645	.650	.650	.650	.650
I	1.125	1.145		1.135	1.135	1.135	1.135	1.135
J	0.990	1.010		1.000	1.000	1.000	1.000	1.000
K	0.235	0.240		.239	.239	.239	.239	.239
L	0.510	0.515		.510	.510	.510	.510	.510
M	0.100	0.120		.119	.120	.120	.120	.120
N	1.565	1.585		1.575	1.575	1.575	1.575	1.575
O	5.990	6.010		6.000	5.998	5.998	6.000	6.000
P	1.245	1.255		1.250	1.250	1.250	1.250	1.250
Q	2.495	2.505		2.500	2.500	2.500	2.500	2.500
R	0.490	0.510		.496	.495	.498	.500	.498
S	0.312	0.318		.312	.312	.312	.312	.312
T	2.495	2.505		2.500	2.500	2.500	2.500	2.500
U	1.357	1.367		1.362	1.362	1.362	1.362	1.362
V	0.315	0.322		.316	.316	.316	.316	.316
W	0.540	0.560		.547	.547	.548	.548	.547
X	1.674	1.684		1.679	1.679	1.679	1.679	1.679
Y	0.256	0.262		.257	.257	.257	.257	.257
Z	0.178	0.198		.188	.188	.188	.188	.188
AA								
AB								
AC								
AD								
AE								
Accept/Reject								

Measured by: Seb/VH	Date: 19/5/23
Audited by: [Signature]	Date: 19/05/23
Prototype Approval:	Date:

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	99.04.19	Incorporated DSI 9095, DSI 9102 & DSI 9122 Rev. A	RF	
C	99.11.10	Added Dim. R-T	RF	
D	02.12.12	Reformat; Added Dim. U-W & DT8683, DT8686 & DT8695 A/B	KJ/RF	
E	06.06.30	Dimension revised per drawing revision C	KJ/JLM	
F	07.03.21	Revised per drawing revision D	KJ/JLM	
G	12.03.08	Dimension S and Y revised	KJ	[Signature]

DART AEROSPACE LTD				Work Order: 193856	
Description: 206 Saddle, Inboard, Right side				Part Number: D2666-2	
Inspection Dwg: D2666 Rev: D DSK: Rev:				Page 1 of 1	

FIRST ARTICLE INSPECTION DIMENSION SHEET

Dim	Min	Max	Go/No Go Gauge	Record Actual Dimensions				
				1	2	3	4	5
A	0.100	0.140		0.121				
B	0.100	0.140		0.123				
C	2.470	2.510		2.495				
D	0.100	0.180		0.130				
E	0.210	0.230		0.224				
F	1.313	1.343		1.324				
G	0.240	0.260		0.254				
H	0.615	0.685		0.650				
I	1.125	1.145		1.135				
J	0.990	1.010		1.000				
K	0.235	0.240		0.239				
L	0.510	0.515		0.510				
M	0.100	0.120		0.120				
N	1.565	1.585		1.575				
O	5.990	6.010		6.000				
P	1.245	1.255		1.250				
Q	2.495	2.505		2.500				
R	0.490	0.510	0.498	0.500				
S	0.312	0.318	3/16	0.312				
T	2.495	2.505		2.500				
U	1.357	1.367	1.362	1.362				
V	0.315	0.322	3/16	0.315				
W	0.540	0.560		0.550				
X	1.674	1.684		1.679				
Y	0.256	0.262		0.257				
Z	0.178	0.198		0.188				
AA								
AB								
AC								
AD								
AE								
Accept/Reject								

Measured by: Seb/11/18	Date: 19/5/23
Audited by: [Signature]	Date: 19/05/23
Prototype Approval:	Date:

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	99.04.19	Incorporated DSI 9095, DSI 9102 & DSI 9122 Rev. A	RF	
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F	07.03.21	Revised per drawing revision D	KJ/JLM	
G	12.03.08	Dimension S and Y revised	KJ	[Signature]

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QS1042)	
Description Work Order Deviation		Disposition			Completed By
					Lead hand / Supervisor
					QC / QA Coordinator
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					